



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2807-041
Job Sheet 170245



Part No: D2807-041

Job Qty: 12 ea

Part Name: Prop Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/12/18

Job Tracking No:

Due Date: 1/22/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV E IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	12 pcs		1/20/18	0.00	0.00	Purchasing		AT 18/01/30
110	Packaging	12 pcs		1/20/18	0.00	0.00	Packaging2		AT 18/01/30
120	QC	12 pcs		1/20/18	0.00	0.00	QC6		38 JAN 31 2018
130	Small Fab	12 pcs		1/22/18	0.00	0.24	Small Fab-2		9-87
140	QC	12 pcs		1/22/18	0.00	0.00	QC5		21 FEB 06 2018
150	Packaging	12 pcs		1/22/18	0.00	0.00	Packaging3-1	5011	21 FEB 06 2018
160	QC21-SA	12 Ea		1/22/18	0.00	0.00	QC21		21 FEB 07 2018

Part Op 100 - Issue P/O: 638782 Order as per Dwg D2807 Possible supplier: Lift Support
Descriptions: Technologies, Saskatoon, Canada P/N 6/15-164/50-115N
110 - Ensure Material Release Note is attached
130 - 1-install D3671-1 as per dwg D2807

JAN 15 2017 QAB

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D3671-1	12	15	0	0
130-Small Fab	6/15-164/50-115N	12	0	0	0

5023201 6x F164411 3x 5038571 3x

Part Specifications

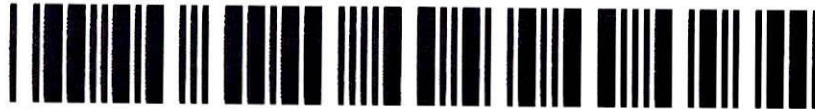
Specifications could not be found.

Plex 1/12/18 11:05 AM dart.lavoie.chantal

DART
AEROSPACE
S036869

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Prop Assembly

PART NO: D2807 – 041

Original Serial #: S036869

Revision:

Operation:

Change No:

Purchasing

Mfg Date: 01/30/18

Job No: 170245

SPECIFICATION CONTROL DRAWING

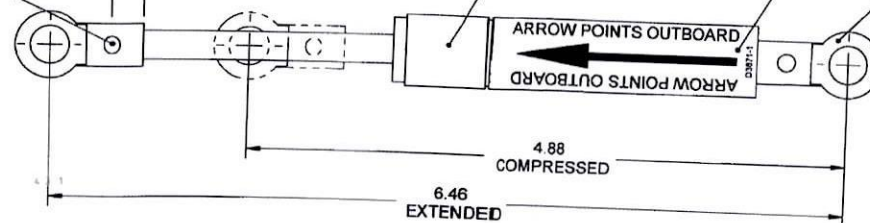
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\varnothing 0.375$ TOOL AT
2000psi (REF) TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

RELEASED
02-11-00

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

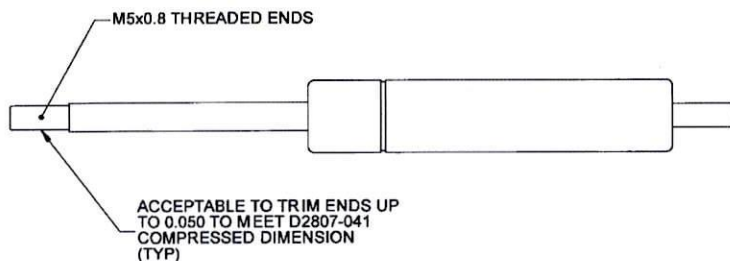
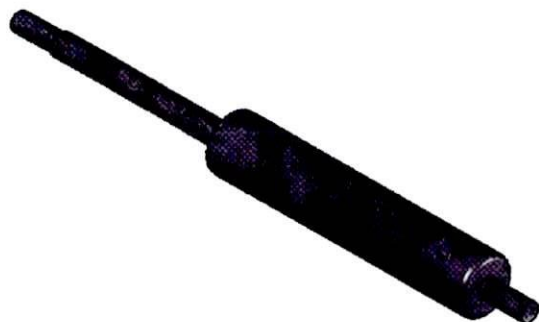
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING; D2807-1/3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D2807
REV. E
SHEET 1 OF 3
TITLE
GAS SPRING
SCALE
NTS

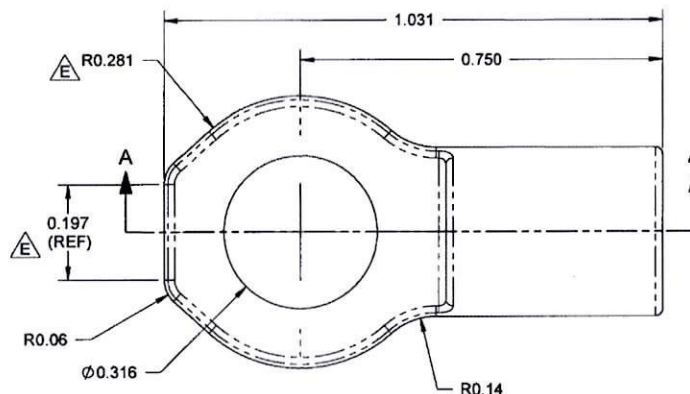
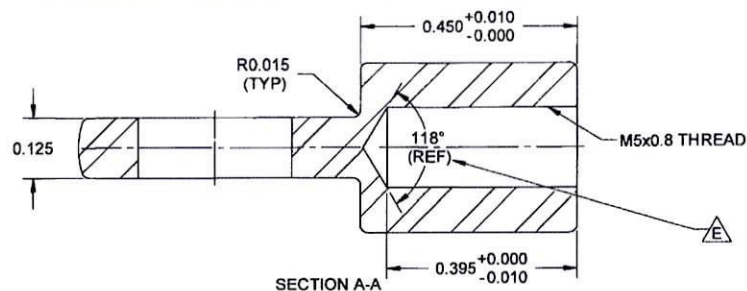
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D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

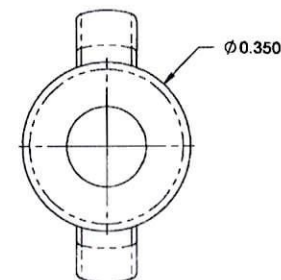
- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



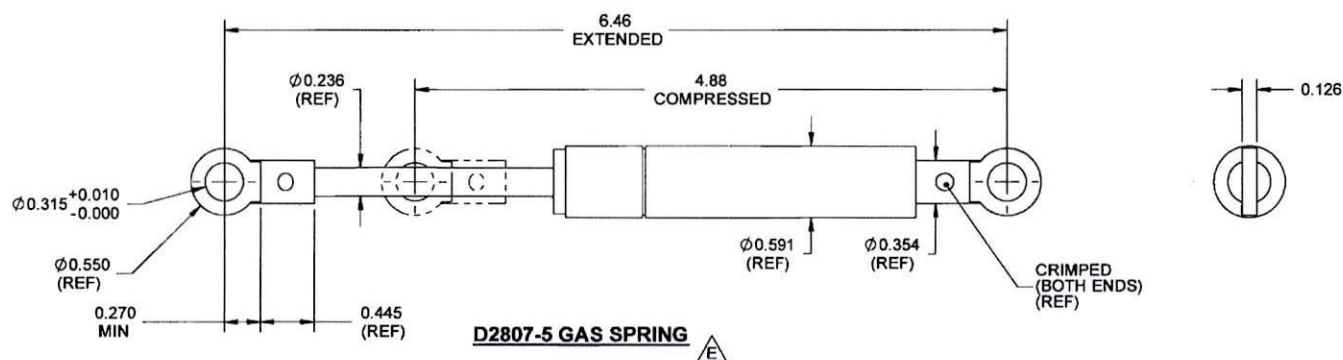
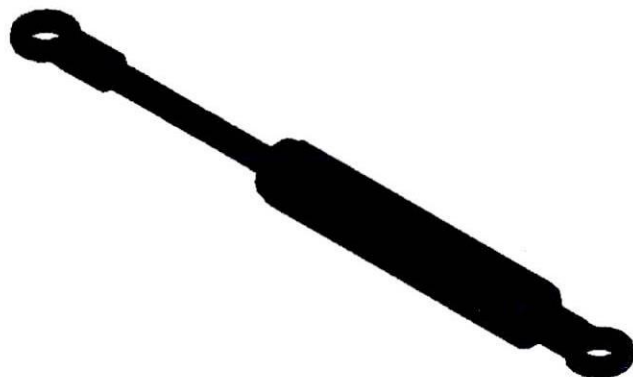
D2807-3 LUG

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.	LE	D2807	SHEET 2 OF 3
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2807-5 GAS SPRING

D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KE	DRAWING NO.	REV. E
MFG. APPR.	KE	D2807	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038782

Supplier: LST001-VC
LS Technologies Inc.
1634 Saskatchewan Ave.
Saskatoon
SK
S7K 1P6 Canada
Phone: 306 683 5000
Fax: 306 683 6403

PO No: PO038782
PO Date: 1/15/18
Due Date: 1/29/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

E-MAILED
JAN 15 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	6/15-164/50-115N			Gas Spring D2807-041 As per Dwg D2807	Firmed	1/29/18	12 pcs	0 pcs 12x	12 pcs	\$51.12/pcs AT 18/01/30	\$613.44
Line Item Note job# 170245											
2	B8-240-575-150N			Gas Spring D3552-11 As Per Dwg D3552	Firmed	1/29/18	8 pcs	0 pcs	8 pcs	\$33.00/pcs	\$264.00
Line Item Note job# 170259											
3	SSA4/6-122-315-310N			Gas Spring D3969-1 As Per Dwg D3969	Firmed	1/29/18	4 pcs	0 pcs	4 pcs	\$51.85/pcs	\$207.40
Line Item Note job# 170260											
4	SSA4/8-122-310-360N			Gas Spring D3969-3 As Per Dwg D3969	Firmed	1/29/18	10 pcs	0 pcs	10 pcs	\$51.85/pcs	\$518.50
Line Item Note job# 170261											
										Grand Total:	\$1,603.34

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

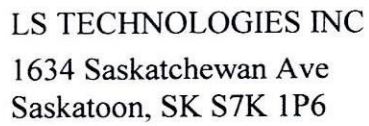
Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

c2
12/3



P.O. No.	Date	Invoice #
038782	1/16/2018	17778

Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Qty	Description
12	D2807-041 B170245 Stainless Gas Spring (6/15-164/50-115N)
	Shipping Via FED EX Tracking # 771228270333

A1 1804 3

Order checked by 



LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Jan 16, 2018

This is to certify that the parts listed below meets specifications as required by your order.

12 Units : D2807-041 B170245 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture: Canada
Date of Manufacture : Jan 2018
This product is ROHS compliant.

Purchase Order # **038782**
Invoice # 17778

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President